

Date: Monday, 5/8/2006 8:06:04 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEDOOR INSTALLATION
Job Number	: 25203		
Estimate Number	: 10568		
P.O. Number	: N/A	Part Number	: D412694011
This Issue	: 5/8/2006 S.O. No. : N/A	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: N/A
Previous Run	: 23693	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 12/19/2005 Qty: 1 Um: Each
Checked & Approved By	: <u>SEE ABOVE USER & DATE</u>		
Comment	: Est Rev:A 05.04.27 New Issue KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-694-011 CHG003

4/10/05 KJ-1

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D412694015	Replacement Window Kit
-----	------------	------------------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 D412-694-015 Replacement Window Kit 3X24745/1X24692

C206/05/08

1

4.0	D41269401	Door Assembly
-----	-----------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D412-694-01 Door Assembly

B24659 → (B2659) W

5.0	D41269402	Door Assembly
-----	-----------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D412-694-02 Door Assembly

B25203 → (B2520) W

Date: Monday, 5/8/2006 8:06:04 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEDOOR INSTALLATION

Job Number: 25203

Part Number: D412694011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D41269403

Door Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D412-694-03 Door Assembly

~~B-24659~~ (2460) u

7.0

D41269404

Door Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D412-694-04 Door Assembly

~~B-25203~~ (2523) ✓
C-260518 (1)

8.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

26/5/8 (1)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-694-011

Location:

PPP Rev: F

26/5/8 (1)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

26/5/08 (1)

Job Completion



u 26-05-08

5/44

B 2659 -01
B. 2660 -03

DART AEROSPACE LTD		Work Order:	24659
Description: Door Assembly		Part Number:	D412-694-01
			D412-694-03
Dwg: D412-694 Rev. B page 2,3,4,5,6		Qty:	1
Ref: D3140 Rev. C page 1, 2		Page 1 of 11	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler for: D3140-5-7 Doubler Kit Issue red decal labels for D412-694-01/-03. CHG003 Batch <u>24659</u>	JH	05.10.25	1
2	PG	For D412-694-011 Issue P/O: <u>2008860</u> <u>ml 06/04/20</u> D3140-05/-07 Door D3119-041 Cover Assembly Supplier: Delastek Ship to Delastek * Qty Part Number Description Batch 1 D3140-5-7 Doubler Kit			
3	RG	Receive and Inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.			
4	QC6	Visual inspection. Check for void spot and pins. Check over all dimensions and windows as per Dwg D3140.		6/4/20 (1) SEE SHEETS ATTACHED	
5	CA	D412-694-01 Drill Process Drill (7) holes using Ø(#40) drill. Drill (3) holes top/bottom Ø(#40) for insert (do not pass thru) using B30-23000-01 as per Dwg D412-694 page 4 (view P).	ml	06/04/24	1
6	CA	Open (1) hole to 11/16" (0.688) for the handle using unibit. Transfer (4) Ø(#30) holes from D3151-041 to the door and c'sink from far side for the rivet. Transfer (2) holes Ø(3/16") for nut plate and c'sink from far side for MS24694-C5 screw as per Dwg D412-694 page 4 (view P). Note: D3151-041 orientation in the door.	ml	06/05/01	1
7	CA	Open (3) holes Ø(#19) or (0.166) top/bottom of the door and c'sink Ø0.300 x 100° from the far side and D3155-041/-042 bracket assembly as per Dwg D412-694 page 4 (view P).	ml	06/05/01	1
8	CA	Drill Ø(#30) holes using drill Jig D3144-T1 for the doublers. Drill (2) holes in two places Ø 3/16" (0.188) for the slot opening. Router slot using D3144-T2/-T3 as per Dwg D412-694 page 2. Note: The (6) holes for the nut plate can not be less than 0.290" from inside edge.	ml	06/05/03	1
9	CA	Open (3) holes to Ø37/64" (0.578) at top/bottom insert for D3163-041 cover assembly as per Dwg D412-694 page 4 (view P).	ml	06/04/24	1
10	CA	Drill Ø(#30) outer door handle as shown in view Z-Z page 2. Open pilot holes to Ø0.257.	ml	06/05/01	1
11	QC5	Inspect work to Step 10	ml	06.05.01	1
12	CA	Drill Pilot holes Ø(#1/8") for rollers using drill Jig DT8703-1. Use unibit to open holes to Ø 37/64" (0.578) for inserts as per Dwg D412-694 page 2, page 6 (view K, L, M, Q).	ml	06/04/24	1
13	CA	Drill Pilot holes Ø(#1/8") for rollers using drill Jig DT8703-2. Use unibit to open holes to Ø 37/64" (0.578) for inserts as per Dwg D412-694 page 2, page 6 (view H, J).	ml	06/04/24	1
14	CA	Drill (27) pilot holes Ø(#30) using drill Jig DT8703-3LH for D3126 brackets as per Dwg D412-694 page 2 (view G-G). Use unibit to open holes Ø37/64" (0.578) for inserts.	ml	06/04/25	1



POSITIVE RECALL

EFFECTIVE 06/04/20 AUTH JD
RELEASED ML DATE 06/05/02

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	24659
Description: Door Assembly	Part Number:	D412-694-01
		D412-694-03
Dwg: D412-694 Rev. B page 2,3,4,5,6	Qty:	1
Ref: D3140 Rev. C page 1, 2		Page 2 of 11

Step	Location	Procedure	By	Date	Qty
15	CA	Drill (2) Pilot holes Ø(#30) by transfer from D3152-041 bracket. Use unibit to open holes to Ø37/64" (0.578) for inserts as per Dwg D412-694 page 6 (view Q).	ml	06/05/01	1
16	CA	Drill (12) Ø(#30) holes using drill Jig D3162-041T1. Compare hole depth with rivet in the foam as per Dwg D412-694 page 4 (view P) and (view R-R/S-S).	ml	06/05/01	1
17	QC5	Inspect work to Step 16	180605 dr		1
18	CA	D412-694-03 Drill Process Drill pilot holes Ø(#30) using drill Jig D3144-T4 for the doublers. Drill (2) holes in two places Ø3/16" (0.188) for the slot opening. Router slot using D3144-T5/-T6 as per Dwg D412-694 page 3. Note: Ensure slot is aligned with mark for reference.	ml	06/04/26	1
19	CA	Drill Pilot holes Ø(#30) using drill Jig D3120-3T1 for bottom cover. Use unibit to open holes to Ø37/64" (0.578) for inserts as per Dwg D412-694 page 3.	AS	06/04/24	1
20	CA	Drill Pilot holes Ø(#30) using drill Jig DT8703-4 for hinges, top cover and D3131-1 spring. Use unibit to open holes to Ø37/64" (0.578) for inserts as per Dwg D412-694 page 3 & 4 (view MM-MM).	AS	06/04/24	1
21	CA	Drill Pilot holes Ø(#1/8") for clevis base and stop at top of the door using drill Jig DT8703-5. Open (1) hole Ø(#10) 0.193 for clevis base and (2) holes Ø(#19) 0.166 for stop as per Dwg D412-694 page 5 (section FF-FF.)	ml	06/04/24	1
22	CA	Drill Pilot hole Ø(#1/8") for clevis base at bottom of the door using drill Jig DT8703-6. Open hole Ø(#10) 0.193 for clevis base as per Dwg D412-694 page 5 (section FF-FF).	ml	06/04/26	1
23	CA	Router 0.225" deep from top surface slot opening for D3112-1 guide using D3112-T1 at bottom of the door as per Dwg D412-694 page 5 (section AA-AA).		N/A	—
24	CA	Router 0.225" deep from top surface slot opening for D3112-1 guide using D3112-T1 at top of the door as per Dwg D412-694 page 5 (section AA-AA).		N/A	—
25	CA	Cut (2) blanks: 0.650" x 2.650" Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch: _____		N/A	—
26	CA	Drill (3) holes Ø(#40) in three locations to guide the plate as per template DT8757.		N/A	—
27	FP	Chemical Conversion Coat (2) plates as per CSI 005 4.1		N/A	—
28	CA	Pre-fit plate in place in the slot opening for D3112-1 guide top/bottom of the door. Bond plate with Hysol, fill slot until approximately 0.050 from the top surface. Qty _____ Description _____ Batch _____ A/R Hysol EA934NA Expiry Date: _____		N/A	—
29	CA	After Hysol cures, drill through only (1) hole Ø(5/8") and pilot drill (2) holes Ø(#30) for insert using drill Jig D3112-T2 for the top of the door. Open (2) holes to 37/64" (0.578) for clevis inserts as per Dwg D412-694 page 5 (section AA-AA).	AS	06/04/25	1

PTO

1 ml

1 ml

PTO

New Design of the door

Do Not Need staple

ml 06/04/20

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
06-04 26	18	Jig DT 3144-T4 to not exist. made Holes with drawing D3140-301A gets transfer drilled	<i>ml</i>				<i>[Signature]</i> 06-05-08	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/05/01	21	Because the D parts was mixed in the box. The Hole of the devs is to high.		make correction on the lever D3125-1 and the rod D3134-3 has to be approved by ing. <i>see box</i>	<i>ml</i> 06/05/01	<i>[Signature]</i> 06-05-08		<i>[Signature]</i> 06-05-08

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	24659
Description: Door Assembly	Part Number:	D412-694-01
		D412-694-03
Dwg: D412-694 Rev. B page 2,3,4,5,6	Qty:	1
Ref: D3140 Rev. C page 1, 2		Page 3 of 11

Step	Location	Procedure	By	Date	Qty																				
30	CA	Drill 17 1/16" from opposite edge of the door through only (1) hole Ø(5/8") and pilot drill (2) holes Ø(#30) using drill Jig D3112-T2 for the bottom of the door. Open (2) Ø(#30) holes to 37/64" (0.578) for clevis inserts as per Dwg D412-694 page 5 (section AA-AA).	ml	06/04/25	1																				
31	CA	Router to the depth of Ø0.150 from the top surface for D3112-1 guide using D3112-T1 at top/bottom of the door as per Dwg D412-694 page 5 (section AA-AA).	ml	N/A	0																				
32	QC5	Inspect work to Step 31	ml	06/05/02	1																				
33	CA	Install inserts as per Dwg D412-694 page 2 (view G-G); page 6 (view H, J, L, M, Q). Pick: (for D412-694-01) <table><tr><td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr><tr><td>55</td><td>80-005-2-8</td><td>Insert</td><td>M12667</td></tr><tr><td>A/R</td><td></td><td>Hysol EA934NA</td><td>M18646</td></tr><tr><td></td><td></td><td>Expiry Date:</td><td>26 Sep 2006</td></tr></table>	Qty	Part Number	Description	Batch	55	80-005-2-8	Insert	M12667	A/R		Hysol EA934NA	M18646			Expiry Date:	26 Sep 2006	ml	06/05/08	1				
Qty	Part Number	Description	Batch																						
55	80-005-2-8	Insert	M12667																						
A/R		Hysol EA934NA	M18646																						
		Expiry Date:	26 Sep 2006																						
		Install inserts as per Dwg D412-694 page 3 & 5 (section AA-AA) and page 4 (view MM-MM). Pick: (for D412-694-03) <table><tr><td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr><tr><td>21</td><td>80-005-2-8</td><td>Insert</td><td>M12667</td></tr><tr><td>A/R</td><td></td><td>Hysol EA934NA</td><td>M19420</td></tr><tr><td></td><td></td><td>Expiry Date:</td><td>22 Dec 2006</td></tr></table>	Qty	Part Number	Description	Batch	21	80-005-2-8	Insert	M12667	A/R		Hysol EA934NA	M19420			Expiry Date:	22 Dec 2006	ml	06/05/01	1				
Qty	Part Number	Description	Batch																						
21	80-005-2-8	Insert	M12667																						
A/R		Hysol EA934NA	M19420																						
		Expiry Date:	22 Dec 2006																						
34	CA	Sand flush excess Hysol around the insert on both doors.	ml	06/05/04	1																				
35	QC5	Inspect that inserts are flush with the surface.	ml	06/05/01	1																				
36	CA	D412-694-01 Assembly Process Install D3162-041 as per Dwg D412-694 page 4 (view R-R/S-S) and D3156-1 bracket as per (view T-T/U-U). Open holes to #30 (0.128) for rivet and alodine the open holes. Note: Start installation window side of the door using M7885/2-4-3 rivet. Pick: <table><tr><td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr><tr><td>2</td><td>D3156-1</td><td>Bracket</td><td>B24706</td></tr><tr><td>12/10</td><td>D3162-041</td><td>Bracket Assembly</td><td>B18957</td></tr><tr><td>12</td><td>M7885/2-4-3</td><td>Rivet</td><td>M19099</td></tr><tr><td>16</td><td>MS20426AD4-7</td><td>Rivet CHANGED</td><td>N/A</td></tr></table>	Qty	Part Number	Description	Batch	2	D3156-1	Bracket	B24706	12/10	D3162-041	Bracket Assembly	B18957	12	M7885/2-4-3	Rivet	M19099	16	MS20426AD4-7	Rivet CHANGED	N/A	ml	06/05/04	1
Qty	Part Number	Description	Batch																						
2	D3156-1	Bracket	B24706																						
12/10	D3162-041	Bracket Assembly	B18957																						
12	M7885/2-4-3	Rivet	M19099																						
16	MS20426AD4-7	Rivet CHANGED	N/A																						
37	CA	Install D3151-041 Doubler as per Dwg D412-694 page 4 (view P). Pick: <table><tr><td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr><tr><td>1</td><td>D3151-041</td><td>Doubler</td><td>B24685</td></tr><tr><td>4</td><td>MS20426AD4-5</td><td>Rivet</td><td>M3459</td></tr></table>	Qty	Part Number	Description	Batch	1	D3151-041	Doubler	B24685	4	MS20426AD4-5	Rivet	M3459	ml	06/05/01	1								
Qty	Part Number	Description	Batch																						
1	D3151-041	Doubler	B24685																						
4	MS20426AD4-5	Rivet	M3459																						

PTO

PTO

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
06/05/01	36	<p>Draw changed w/o has to be updated</p> <p>Now use 10 - D 3162-041 <u>B24976</u> using <u>B M15659</u></p> <p>1 D 3162-043 <u>B24976</u></p> <p>1 D 3162-044 <u>B24977</u> 14 rivets M 7885/3-4-4</p>	ml	06/05/04			06-05-06	
06/05/02	35	<p>after step 35. The new w/o will say that we have</p> <p>to Re-prime around all inserts and</p> <p>where they need.</p> <p>So: Re-prime the where they need.</p> <p>M100407</p> <p>M100375</p>	ml	06/05/02			06-05-06	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	24659
Description: Door Assembly	Part Number:	D412-694-01
		D412-694-03
Dwg: D412-694 Rev. B page 2,3,4,5,6	Qty:	1
Ref: D3140 Rev. C page 1, 2		Page 4 of 11

Step	Location	Procedure	By	Date	Qty																																																								
38	CA	<p>Connect D3132-041 Rod Weldment with D3122-1 Lever and D3133-041 Rod Weldment as per Dwg D412-694 page 4 (view P).</p> <p>Pick:</p> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>1</td><td>D3122-1</td><td>Lever</td><td>B25539</td></tr><tr><td>1</td><td>D3132-041</td><td>Rod Weldment</td><td>m10536-17</td></tr><tr><td>1</td><td>D3133-042</td><td>Rod Weldment</td><td>m10536-17</td></tr><tr><td>2</td><td>D3148-1</td><td>Clevis</td><td>m10536-17</td></tr><tr><td>2</td><td>AN960JD10L</td><td>Washer</td><td>M16612</td></tr><tr><td>2</td><td>MS20392-2C9</td><td>Pin</td><td>m11784</td></tr><tr><td>2</td><td>MS24665-151</td><td>Cotter Pin</td><td>m17566</td></tr><tr><td>2</td><td>MS35650-3252</td><td>Nut</td><td>m11735</td></tr></tbody></table>	Qty	Part Number	Description	Batch	1	D3122-1	Lever	B25539	1	D3132-041	Rod Weldment	m10536-17	1	D3133-042	Rod Weldment	m10536-17	2	D3148-1	Clevis	m10536-17	2	AN960JD10L	Washer	M16612	2	MS20392-2C9	Pin	m11784	2	MS24665-151	Cotter Pin	m17566	2	MS35650-3252	Nut	m11735	ml	06/04/25	1																				
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1	D3122-1	Lever	B25539																																																										
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2	MS24665-151	Cotter Pin	m17566																																																										
2	MS35650-3252	Nut	m11735																																																										
39	CA	<p>Assemble D3123-1 Cam with D3124-1/-2 Hook with D3155-041/-042 Bracket Assembly as per Dwg D412-694 page 4 (view P).</p> <p>Pick:</p> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>2</td><td>D3123-1</td><td>Cam</td><td>m10536-17</td></tr><tr><td>1</td><td>D3124-1</td><td>Hook</td><td>m10536-17</td></tr><tr><td>1</td><td>D3124-2</td><td>Hook</td><td>m10536-17</td></tr><tr><td>1</td><td>D3155-041</td><td>Bracket Assembly</td><td>B24686</td></tr><tr><td>1</td><td>D3155-042</td><td>Bracket Assembly</td><td>B24343</td></tr><tr><td>2</td><td>MS35275-233</td><td>Screw</td><td>m11822</td></tr><tr><td>2</td><td>MS35649-264</td><td>Nut</td><td>m11822</td></tr></tbody></table>	Qty	Part Number	Description	Batch	2	D3123-1	Cam	m10536-17	1	D3124-1	Hook	m10536-17	1	D3124-2	Hook	m10536-17	1	D3155-041	Bracket Assembly	B24686	1	D3155-042	Bracket Assembly	B24343	2	MS35275-233	Screw	m11822	2	MS35649-264	Nut	m11822	ml	06/04/08	1																								
Qty	Part Number	Description	Batch																																																										
2	D3123-1	Cam	m10536-17																																																										
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1	D3124-2	Hook	m10536-17																																																										
1	D3155-041	Bracket Assembly	B24686																																																										
1	D3155-042	Bracket Assembly	B24343																																																										
2	MS35275-233	Screw	m11822																																																										
2	MS35649-264	Nut	m11822																																																										
40	CA	<p>Install D3203-1 handle with D3308-1 doubler as per Dwg D412-694 page 2 (view Z-Z).</p> <p>Pick:</p> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>1</td><td>D3203-1</td><td>Handle</td><td>B24956A</td></tr><tr><td>2</td><td>D3308-1</td><td>Doubler</td><td>B21912</td></tr><tr><td>4</td><td>AN960JD416L</td><td>Washer</td><td>m3154</td></tr><tr><td>4</td><td>MS21042L4</td><td>Nut (or -4)</td><td>m15020</td></tr><tr><td>4</td><td>MS24694-S98</td><td>Screw</td><td>m16255</td></tr></tbody></table>	Qty	Part Number	Description	Batch	1	D3203-1	Handle	B24956A	2	D3308-1	Doubler	B21912	4	AN960JD416L	Washer	m3154	4	MS21042L4	Nut (or -4)	m15020	4	MS24694-S98	Screw	m16255	⊗	04/05/02	1																																
Qty	Part Number	Description	Batch																																																										
1	D3203-1	Handle	B24956A																																																										
2	D3308-1	Doubler	B21912																																																										
4	AN960JD416L	Washer	m3154																																																										
4	MS21042L4	Nut (or -4)	m15020																																																										
4	MS24694-S98	Screw	m16255																																																										
41.	CA	<p>Install D3155-041/-042 Bracket Assembly and D3110-5 Handle as per Dwg D412-694 page 4 (view P) and page 2. Adjust rod weldment until everything works properly and looks in place.</p> <p>Pick:</p> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>1</td><td>D3110-5</td><td>Handle Assembly</td><td>B25502</td></tr><tr><td>1</td><td>D3127-1</td><td>Spacer</td><td>N/A</td></tr><tr><td>2</td><td>D3141-1</td><td>Spring</td><td>B24342C</td></tr><tr><td>2</td><td>AN960JD10L</td><td>Washer</td><td>m16612</td></tr><tr><td>2</td><td>AN960JD416L</td><td>Washer</td><td>m3154</td></tr><tr><td>6</td><td>AN960JD8</td><td>Washer</td><td>m11989</td></tr><tr><td>2</td><td>MS20392-2C17</td><td>Pin</td><td>m11735</td></tr><tr><td>2</td><td>MS20392-3C21</td><td>Pin</td><td>m11765</td></tr><tr><td>6</td><td>MS21042L08</td><td>Nut (or -8)</td><td>m15003</td></tr><tr><td>4</td><td>MS24665-151</td><td>Cotter Pin</td><td>m17566</td></tr><tr><td>4</td><td>MS24694-C5</td><td>Screw</td><td>m11755</td></tr><tr><td>6</td><td>MS24694-S5</td><td>Screw</td><td>m11735</td></tr><tr><td>2</td><td>MS51859-7</td><td>Washer</td><td>m11822</td></tr></tbody></table>	Qty	Part Number	Description	Batch	1	D3110-5	Handle Assembly	B25502	1	D3127-1	Spacer	N/A	2	D3141-1	Spring	B24342C	2	AN960JD10L	Washer	m16612	2	AN960JD416L	Washer	m3154	6	AN960JD8	Washer	m11989	2	MS20392-2C17	Pin	m11735	2	MS20392-3C21	Pin	m11765	6	MS21042L08	Nut (or -8)	m15003	4	MS24665-151	Cotter Pin	m17566	4	MS24694-C5	Screw	m11755	6	MS24694-S5	Screw	m11735	2	MS51859-7	Washer	m11822	ml	06/04/08	1
Qty	Part Number	Description	Batch																																																										
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PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	24659
Description: Door Assembly	Part Number:	D412-694-01
		D412-694-03
Dwg: D412-694 Rev. B page 2,3,4,5,6	Qty:	1
Ref: D3140 Rev. C page 1, 2		Page 5 of 11

Step	Location	Procedure	By	Date	Qty																												
42	CA	<p>Install D3116-7-0680 Seal and doublers. Transfer slot opening in the seal as per Dwg D412-694 page 2 (view V-V and N).</p> <p>Pick:</p> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3116-7-0680</td><td>Seal</td><td>B 23089</td></tr><tr><td>1</td><td>D3144-3</td><td>Doubler</td><td>B 18816</td></tr><tr><td>1</td><td>D3144-109</td><td>Doubler</td><td>B 23145</td></tr><tr><td>1</td><td>D3144-111</td><td>Doubler</td><td>B 21910</td></tr><tr><td>40445</td><td>BSP45</td><td>Rivet</td><td>M 11821</td></tr><tr><td>824</td><td>BSP46</td><td>Rivet</td><td>M 19098</td></tr></table>	Qty	Part Number	Description	Batch	1	D3116-7-0680	Seal	B 23089	1	D3144-3	Doubler	B 18816	1	D3144-109	Doubler	B 23145	1	D3144-111	Doubler	B 21910	40445	BSP45	Rivet	M 11821	824	BSP46	Rivet	M 19098	ml	06/05/04	1
Qty	Part Number	Description	Batch																														
1	D3116-7-0680	Seal	B 23089																														
1	D3144-3	Doubler	B 18816																														
1	D3144-109	Doubler	B 23145																														
1	D3144-111	Doubler	B 21910																														
40445	BSP45	Rivet	M 11821																														
824	BSP46	Rivet	M 19098																														
43	CA	<p>Install D3110-5 Handle Assembly in the D3163-041 Cover Assembly. Ensure Handle works freely. Ensure D3163-041 cover assembly is aligned with the door edge on both sides and D3110-5 Handle works properly.</p> <p>Pick:</p> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3163-041</td><td>Cover Assembly</td><td>224346</td></tr></table> <p>When the cover is clamped, start to make the holes with the hole finder by the (4) holes around the D3110-5 handle. Follow the shape & work your way out of the door top and bottom.</p> <p>Transfer pilot Ø (#30) holes from D3162-041 bracket to D3163-041 cover assembly and D3135-041 handle weldment using hole finder. Install D3163-041 Cover and D3135-041 Handle Weldment as per Dwg D412-694 page 2.</p> <p>Pick:</p> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3135-041</td><td>Handle Weldment</td><td>B 19861</td></tr><tr><td>10</td><td>AN525-10R6</td><td>Screw</td><td>M 15943</td></tr><tr><td>8</td><td>AN525-10R7</td><td>Screw</td><td>M 15387</td></tr></table>	Qty	Part Number	Description	Batch	1	D3163-041	Cover Assembly	224346	Qty	Part Number	Description	Batch	1	D3135-041	Handle Weldment	B 19861	10	AN525-10R6	Screw	M 15943	8	AN525-10R7	Screw	M 15387	ml	06/05/04	1				
Qty	Part Number	Description	Batch																														
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10	AN525-10R6	Screw	M 15943																														
8	AN525-10R7	Screw	M 15387																														
44	CA	<p>Open 15/64" (0.234) holes to D3163-041 cover assembly and D3135-041 handle weldment. Transfer D3139-1/-3 guard holes in cover assembly and drill holes for nutplate. Deburr and touch up holes with alodine as per Dwg D412-694 page 2.</p>	ml	06/05/04	1																												
45	CA	<p>Install MS21072-L3 Nutplate and Guard as per Dwg D412-694 page 2. Finish installing D3163-041 in the door.</p> <p>Pick:</p> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3139-1</td><td>Guard</td><td>B 18863</td></tr><tr><td>1</td><td>D3139-3</td><td>Guard</td><td>B 24700</td></tr><tr><td>8</td><td>MS20426AD3-3</td><td>Rivet</td><td>M 1563</td></tr><tr><td>4</td><td>MS21072-L3</td><td>Nutplate 1 @ M 18728</td><td>3 @ M 11760</td></tr><tr><td>4</td><td>MS24693-S271</td><td>Screw</td><td>M 14478</td></tr></table>	Qty	Part Number	Description	Batch	1	D3139-1	Guard	B 18863	1	D3139-3	Guard	B 24700	8	MS20426AD3-3	Rivet	M 1563	4	MS21072-L3	Nutplate 1 @ M 18728	3 @ M 11760	4	MS24693-S271	Screw	M 14478	ml	06/05/04	1				
Qty	Part Number	Description	Batch																														
1	D3139-1	Guard	B 18863																														
1	D3139-3	Guard	B 24700																														
8	MS20426AD3-3	Rivet	M 1563																														
4	MS21072-L3	Nutplate 1 @ M 18728	3 @ M 11760																														
4	MS24693-S271	Screw	M 14478																														
46	QC5	Inspect work to Step 45	J	06.05.04	1																												

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06-05-04	45	Used Qty 4 of MS24693-S27 (M14470) screws to put in nut plates for paint protection on threads	<i>[Signature]</i>	06/05/04	4		<i>[Signature]</i> 060508

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/05/04	45	MS24693-S27 screws M14470 Qty @ 4		Screw used in plate nuts for painting procedure Remove from stock	<i>[Signature]</i> 06/05/04			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	24659
Description: Door Assembly	Part Number:	D412-694-01
		D412-694-03
Dwg: D412-694 Rev. B page 2,3,4,5,6	Qty:	1
Ref: D3140 Rev. C page 1, 2		Page 6 of 11

Step	Location	Procedure	By	Date	Qty																																												
47	CA	<p>Transfer (#30) holes from D3144-13 doubler to seal and door. Ensure D3116-9-0770 is properly aligned as per Dwg D412-694 page 2 (section NN-NN). Apply 732 RTV Clear (A/R) in the hole prior to installing rivet and then in the rivet head after installation.</p> <p>Pick:</p> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>1</td><td>D3116-9-0770</td><td>Seal</td><td>B17463</td></tr><tr><td>1</td><td>D3144-13</td><td>Doubler</td><td>B21911</td></tr><tr><td>39</td><td>BSP45</td><td>Rivet</td><td>M11821</td></tr><tr><td>A/R</td><td></td><td>732 RTV Clear</td><td>M16368</td></tr><tr><td></td><td></td><td>Expiry Date:</td><td>17 Feb 2007</td></tr></tbody></table>	Qty	Part Number	Description	Batch	1	D3116-9-0770	Seal	B17463	1	D3144-13	Doubler	B21911	39	BSP45	Rivet	M11821	A/R		732 RTV Clear	M16368			Expiry Date:	17 Feb 2007	ml	06/05/03	1																				
Qty	Part Number	Description	Batch																																														
1	D3116-9-0770	Seal	B17463																																														
1	D3144-13	Doubler	B21911																																														
39	BSP45	Rivet	M11821																																														
A/R		732 RTV Clear	M16368																																														
		Expiry Date:	17 Feb 2007																																														
48	CA	<p>Install D3126 Brackets and D3138-1 Cover as per Dwg D412-694 page 2 (view G-G and NN-NN).</p> <p>Pick:</p> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>1</td><td>D3126-1</td><td>Bracket</td><td>B24679</td></tr><tr><td>1</td><td>D3126-3</td><td>Bracket</td><td>B24680</td></tr><tr><td>5</td><td>D3126-5</td><td>Bracket</td><td>B18658 A</td></tr><tr><td>1</td><td>D3138-1</td><td>Cover</td><td>B25178</td></tr><tr><td>14</td><td>AN960JD10L</td><td>Washer</td><td>M16612</td></tr><tr><td>13</td><td>AN960JD10LL</td><td>Washer</td><td>M11763</td></tr><tr><td>14</td><td>MS27039-1-06</td><td>Screw</td><td>M11754</td></tr><tr><td>13</td><td>MS27039-1-08</td><td>Screw</td><td>M13356</td></tr><tr><td>7</td><td>NAS43DD3-10</td><td>Spacer</td><td>M11764</td></tr><tr><td>6</td><td>NAS43DD3-14</td><td>Spacer</td><td>M11785</td></tr></tbody></table>	Qty	Part Number	Description	Batch	1	D3126-1	Bracket	B24679	1	D3126-3	Bracket	B24680	5	D3126-5	Bracket	B18658 A	1	D3138-1	Cover	B25178	14	AN960JD10L	Washer	M16612	13	AN960JD10LL	Washer	M11763	14	MS27039-1-06	Screw	M11754	13	MS27039-1-08	Screw	M13356	7	NAS43DD3-10	Spacer	M11764	6	NAS43DD3-14	Spacer	M11785	ml	06/05/03	1
Qty	Part Number	Description	Batch																																														
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1	D3138-1	Cover	B25178																																														
14	AN960JD10L	Washer	M16612																																														
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7	NAS43DD3-10	Spacer	M11764																																														
6	NAS43DD3-14	Spacer	M11785																																														
49	CA	<p>Install and assemble brackets as per Dwg D412-694 page 2 and 5 (view H, J, L, M and Q).</p> <p>Pick:</p> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>1</td><td>D3115-1</td><td>Bracket</td><td>B18631</td></tr><tr><td>3</td><td>D3121-041</td><td>Bracket Assembly</td><td>B24677</td></tr><tr><td>1</td><td>D3121-043</td><td>Bracket Assembly</td><td>B24699</td></tr><tr><td>1</td><td>D3137-041-045</td><td>Bracket Assembly</td><td>B25467</td></tr><tr><td>1</td><td>D3152-041</td><td>Bracket Assembly</td><td>B25284</td></tr><tr><td>1</td><td>D3183-041</td><td>Bracket Assembly</td><td>B21385</td></tr><tr><td>2</td><td>AN525-10R6</td><td>Screw</td><td>M15943</td></tr><tr><td>2</td><td>AN960JD10LL</td><td>Washer</td><td>M11763</td></tr><tr><td>18</td><td>MS24694-S50</td><td>Screw</td><td>M14206</td></tr><tr><td>2</td><td>MS27039-1-05</td><td>Screw</td><td>M3501</td></tr></tbody></table>	Qty	Part Number	Description	Batch	1	D3115-1	Bracket	B18631	3	D3121-041	Bracket Assembly	B24677	1	D3121-043	Bracket Assembly	B24699	1	D3137-041-045	Bracket Assembly	B25467	1	D3152-041	Bracket Assembly	B25284	1	D3183-041	Bracket Assembly	B21385	2	AN525-10R6	Screw	M15943	2	AN960JD10LL	Washer	M11763	18	MS24694-S50	Screw	M14206	2	MS27039-1-05	Screw	M3501	ml	06/05/03	1
Qty	Part Number	Description	Batch																																														
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2	MS27039-1-05	Screw	M3501																																														
50	QC5	Inspect work to Step 49																																															

Now we using D3137-045. The drawing was upgraded
This is an old w/p.

ml 06/04/27

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	<i>24659</i>
Description: Door Assembly	Part Number:	D412-694-01
		D412-694-03
Dwg: D412-694 Rev. B page 2,3,4,5,6	Qty:	<i>1</i>
Ref: D3140 Rev. C page 1, 2		Page 7 of 11

Step	Location	Procedure	By	Date	Qty																																																																								
51	CA	<p>D412-694-03 Assembly Process</p> <p>Install top/bottom of the door, D3112-1 Guard, D3130-1 Clevis Base and D3131-1 Stop (top only) as per Dwg D412-694 page 5 (section AA-AA & FF-FF).</p> <p>Pick:</p> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>2</td><td>D3112-1</td><td>Guide</td><td>B24674</td></tr><tr><td>2</td><td>D3130-1</td><td>Clevis Base</td><td>M10536-17</td></tr><tr><td>1</td><td>D3131-1</td><td>Stop</td><td>M10536-17</td></tr><tr><td>4</td><td>AN525-10R7</td><td>Screw</td><td>M15387</td></tr><tr><td>4</td><td>AN960JD6L</td><td>Washer</td><td>M5519</td></tr><tr><td>2</td><td>AN960JD10LL</td><td>Washer</td><td>M11763</td></tr><tr><td>2</td><td>MS21042L06</td><td>Nut (or -6)</td><td>M17771</td></tr><tr><td>2</td><td>MS27039-1-06</td><td>Screw</td><td>M11754</td></tr><tr><td>2</td><td>MS35206-231</td><td>Screw</td><td>M11735</td></tr></tbody></table>	Qty	Part Number	Description	Batch	2	D3112-1	Guide	B24674	2	D3130-1	Clevis Base	M10536-17	1	D3131-1	Stop	M10536-17	4	AN525-10R7	Screw	M15387	4	AN960JD6L	Washer	M5519	2	AN960JD10LL	Washer	M11763	2	MS21042L06	Nut (or -6)	M17771	2	MS27039-1-06	Screw	M11754	2	MS35206-231	Screw	M11735	ml	06/05/04	1																																
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2	MS27039-1-06	Screw	M11754																																																																										
2	MS35206-231	Screw	M11735																																																																										
52	CA	<p>Install D3111-041 Plate Assembly. If needed, install temporary D3110-3 Handle as per Dwg D412-694 page 5 (view W and section BB-BB).</p> <p>Note: Adjust D3111-041 high with washer as required. Check that the D3154-1 key doesn't touch the base of the door.</p> <p>Pick:</p> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>1</td><td>D3110-3</td><td>Handle</td><td>B17293</td></tr><tr><td>1</td><td>D3111-041</td><td>Plate Assembly</td><td>M10536-17</td></tr><tr><td>1</td><td>D3125-3</td><td>Lever</td><td>M10536-17</td></tr><tr><td>1</td><td>D3125-5</td><td>Lever</td><td>M10536-17</td></tr><tr><td>2</td><td>D3129-1</td><td>Lever</td><td>M10536-17</td></tr><tr><td>1</td><td>D3154-1</td><td>Key</td><td>M10536-17</td></tr><tr><td>2</td><td>D3157-1</td><td>Spacer</td><td>M10536-17</td></tr><tr><td>8</td><td>AN960JD10</td><td>Washer</td><td>M19521</td></tr><tr><td>5</td><td>AN960JD10LL</td><td>Washer</td><td>M11763</td></tr><tr><td>4</td><td>FW10-032</td><td>Washer</td><td>M11822</td></tr><tr><td>2</td><td>MS20392-2C11</td><td>Pin</td><td>M14149</td></tr><tr><td>1</td><td>MS21042L3</td><td>Nut (or -3)</td><td>M15539</td></tr><tr><td>2</td><td>MS24665-151</td><td>Cotter Pin</td><td>M14526</td></tr><tr><td>4</td><td>MS24694-S60</td><td>Screw</td><td>M11766</td></tr><tr><td>3</td><td>MS51859-7</td><td>Washer</td><td>M11822</td></tr><tr><td>4</td><td>NAS1169-10L</td><td>Washer</td><td>M11753</td></tr><tr><td>2</td><td>NAS43DD3-40</td><td>Spacer</td><td>M11737</td></tr></tbody></table>	Qty	Part Number	Description	Batch	1	D3110-3	Handle	B17293	1	D3111-041	Plate Assembly	M10536-17	1	D3125-3	Lever	M10536-17	1	D3125-5	Lever	M10536-17	2	D3129-1	Lever	M10536-17	1	D3154-1	Key	M10536-17	2	D3157-1	Spacer	M10536-17	8	AN960JD10	Washer	M19521	5	AN960JD10LL	Washer	M11763	4	FW10-032	Washer	M11822	2	MS20392-2C11	Pin	M14149	1	MS21042L3	Nut (or -3)	M15539	2	MS24665-151	Cotter Pin	M14526	4	MS24694-S60	Screw	M11766	3	MS51859-7	Washer	M11822	4	NAS1169-10L	Washer	M11753	2	NAS43DD3-40	Spacer	M11737	ml	06/05/04	1
Qty	Part Number	Description	Batch																																																																										
1	D3110-3	Handle	B17293																																																																										
1	D3111-041	Plate Assembly	M10536-17																																																																										
1	D3125-3	Lever	M10536-17																																																																										
1	D3125-5	Lever	M10536-17																																																																										
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5	AN960JD10LL	Washer	M11763																																																																										
4	FW10-032	Washer	M11822																																																																										
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4	NAS1169-10L	Washer	M11753																																																																										
2	NAS43DD3-40	Spacer	M11737																																																																										

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries


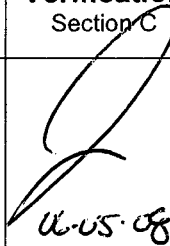
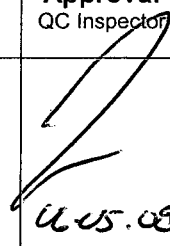
QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	24659
Description: Door Assembly	Part Number:	D412-694-01
		D412-694-03
Dwg: D412-694 Rev. B page 2,3,4,5,6	Qty:	1
Ref: D3140 Rev. C page 1, 2		Page 8 of 11

Step	Location	Procedure	By	Date	Qty																																																
53	CA	Assemble Rod as per Dwg D412-694 page 5 (view W) Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3125-1</td><td>Lever</td><td>M10536-17</td></tr><tr><td>1</td><td>D3125-7</td><td>Lever</td><td>M10536-17</td></tr><tr><td>1</td><td>D3134-1</td><td>Rod</td><td>B24490</td></tr><tr><td>1</td><td>D3134-3</td><td>Rod</td><td>B24682</td></tr><tr><td>1</td><td>D3143-1</td><td>Clevis</td><td>M10536-17</td></tr><tr><td>3</td><td>D3143-3</td><td>Clevis</td><td>M10536-17</td></tr><tr><td>5</td><td>AN960JD10L</td><td>Washer</td><td>M16612</td></tr><tr><td>10</td><td>FW10-032</td><td>Washer</td><td>M11822</td></tr><tr><td>5</td><td>MS20392-2C15</td><td>Pin</td><td>M11796</td></tr><tr><td>5</td><td>MS24665-151</td><td>Cotter Pin</td><td>M17566</td></tr><tr><td>4</td><td>MS35650-305T</td><td>Nut</td><td>M11786</td></tr></table>	Qty	Part Number	Description	Batch	1	D3125-1	Lever	M10536-17	1	D3125-7	Lever	M10536-17	1	D3134-1	Rod	B24490	1	D3134-3	Rod	B24682	1	D3143-1	Clevis	M10536-17	3	D3143-3	Clevis	M10536-17	5	AN960JD10L	Washer	M16612	10	FW10-032	Washer	M11822	5	MS20392-2C15	Pin	M11796	5	MS24665-151	Cotter Pin	M17566	4	MS35650-305T	Nut	M11786	ml	06/05/08	1
Qty	Part Number	Description	Batch																																																		
1	D3125-1	Lever	M10536-17																																																		
1	D3125-7	Lever	M10536-17																																																		
1	D3134-1	Rod	B24490																																																		
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3	D3143-3	Clevis	M10536-17																																																		
5	AN960JD10L	Washer	M16612																																																		
10	FW10-032	Washer	M11822																																																		
5	MS20392-2C15	Pin	M11796																																																		
5	MS24665-151	Cotter Pin	M17566																																																		
4	MS35650-305T	Nut	M11786																																																		
54	CA	Assemble D3147-1 Pin to the lever as per Dwg D412-694 page 5 (section AA-AA & FF-FF). Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>D3147-1</td><td>Pin</td><td>M10536-17</td></tr><tr><td>2</td><td>AN960JD8</td><td>Washer</td><td>M11989</td></tr><tr><td>2</td><td>AN960JD8L</td><td>Washer</td><td>M6956</td></tr><tr><td>6</td><td>FW4-032</td><td>Washer</td><td>M11822</td></tr><tr><td>2</td><td>MS20392-1C11</td><td>Pin</td><td>M11735</td></tr><tr><td>2</td><td>MS24665-151</td><td>Cotter Pin</td><td>M17566</td></tr></table>	Qty	Part Number	Description	Batch	2	D3147-1	Pin	M10536-17	2	AN960JD8	Washer	M11989	2	AN960JD8L	Washer	M6956	6	FW4-032	Washer	M11822	2	MS20392-1C11	Pin	M11735	2	MS24665-151	Cotter Pin	M17566	ml	06/04/07	1																				
Qty	Part Number	Description	Batch																																																		
2	D3147-1	Pin	M10536-17																																																		
2	AN960JD8	Washer	M11989																																																		
2	AN960JD8L	Washer	M6956																																																		
6	FW4-032	Washer	M11822																																																		
2	MS20392-1C11	Pin	M11735																																																		
2	MS24665-151	Cotter Pin	M17566																																																		
55	CA	Connect Rods and D3111-041 Plate Assembly from Step 54 & 55 as per Dwg D412-694 page 5 (view W). Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>6</td><td>AN960JD10L</td><td>Washer</td><td>M16612</td></tr><tr><td>8</td><td>FW10-032</td><td>Washer</td><td>M11822</td></tr><tr><td>2</td><td>MS20392-2C15</td><td>Pin</td><td>M11796</td></tr><tr><td>2</td><td>MS24665-151</td><td>Cotter Pin</td><td>M17566</td></tr></table>	Qty	Part Number	Description	Batch	6	AN960JD10L	Washer	M16612	8	FW10-032	Washer	M11822	2	MS20392-2C15	Pin	M11796	2	MS24665-151	Cotter Pin	M17566	ml	06/05/05	1																												
Qty	Part Number	Description	Batch																																																		
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2	MS20392-2C15	Pin	M11796																																																		
2	MS24665-151	Cotter Pin	M17566																																																		
56	CA	Install D3111-041 and mechanism in place. Use D3110-3 Handle to make lock and mechanism of the rod work properly. Mark the center NAS1169-10L washer into the door and drill (#10) Ø0.193". C'sink Ø0.385 x 100° from far side of the door. Ensure D3111-041 is level with inside door surface as per Dwg D412-694 page 5 (view W). Use washers from step 55 as required to level.	ml	06/05/08	1																																																
57	QC5	Inspect work to Step 56		06-08	1																																																
58	CA	Install (1) D3159-041 bracket assembly to side of the window. Transfer hole from the door to D3159-041 bracket. Drill Ø(#30) C'sink for the rivet (note: use 1" pitch holes) as per Dwg D412-694 page 5 (view W) and (section LL-LL). Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>3</td><td>D3159-041</td><td>Bracket Assembly</td><td>B18641</td></tr><tr><td>2</td><td>M7885/3-4-4</td><td>Rivet</td><td>M15659</td></tr></table>	Qty	Part Number	Description	Batch	3	D3159-041	Bracket Assembly	B18641	2	M7885/3-4-4	Rivet	M15659	ml	06/05/04	1																																				
Qty	Part Number	Description	Batch																																																		
3	D3159-041	Bracket Assembly	B18641																																																		
2	M7885/3-4-4	Rivet	M15659																																																		

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/04/02	53	Because step 2/ the modification of the rod D 3134-3 was no good.		Have to make a New one . 500" longer. (See sheet attached) <u>M 100839</u>	 06/05/08	 U-05-08		 U-05-08

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	24659
Description: Door Assembly	Part Number:	D412-694-01
		D412-694-03
Dwg: D412-694 Rev. B page 2,3,4,5,6	Qty:	1
Ref: D3140 Rev. C page 1, 2		Page 9 of 11

Step	Location	Procedure	By	Date	Qty																												
59	CA	<p>Drill (#19), C'sink Ø0.332 x 100°. Install MS25281-R6 Clamp as per Dwg D412-694 page 5 (view W). Ensure Rod moves freely when installing clamps.</p> <p>Pick:</p> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>AN960JD10L</td><td>Washer</td><td>M16612</td></tr><tr><td>2</td><td>AN960JD10LL</td><td>Washer</td><td>M11763</td></tr><tr><td>2</td><td>MS21042L3</td><td>Nut (or -3)</td><td>M15539</td></tr><tr><td>2</td><td>MS24694-S56553</td><td>Screw M15798</td><td>M14498</td></tr><tr><td>2</td><td>MS25281-R6</td><td>Clamp</td><td>M11759</td></tr></table>	Qty	Part Number	Description	Batch	2	AN960JD10L	Washer	M16612	2	AN960JD10LL	Washer	M11763	2	MS21042L3	Nut (or -3)	M15539	2	MS24694-S56553	Screw M15798	M14498	2	MS25281-R6	Clamp	M11759	ml	06/05/04	1				
Qty	Part Number	Description	Batch																														
2	AN960JD10L	Washer	M16612																														
2	AN960JD10LL	Washer	M11763																														
2	MS21042L3	Nut (or -3)	M15539																														
2	MS24694-S56553	Screw M15798	M14498																														
2	MS25281-R6	Clamp	M11759																														
60	CA	<p>Install (1) D3159-043 bracket assembly. Transfer (2) holes from the door to the bracket. Install (1) M7885/3-4-5 rivet and install the second rivet with the doubler.</p> <p>Note: Layout properly as per Dwg D412-694 page 5 (view W).</p> <p>Note: Second hole will be done with doubler and seal.</p> <p>Pick:</p> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3159-043</td><td>Bracket Assembly</td><td>B324707</td></tr><tr><td>1</td><td>M7885/3-4-5</td><td>Rivet</td><td>M1108</td></tr></table>	Qty	Part Number	Description	Batch	1	D3159-043	Bracket Assembly	B324707	1	M7885/3-4-5	Rivet	M1108	ml	06/05/04	1																
Qty	Part Number	Description	Batch																														
1	D3159-043	Bracket Assembly	B324707																														
1	M7885/3-4-5	Rivet	M1108																														
61	CA	<p>Drill (4) (#10) Ø0.193" holes from D3150-1 guide by laying out doublers with temporary seal segment with strike plate. Check location of strike plate by laying out small and large door together.</p> <p>Note: Position strike plate when big door is in locked position.</p>	ml	06/05/01	1																												
62	CA	<p>Drill Pilot holes Ø(#1/8") for D3119-041 cover using drilling Jig D3119-041T1/T2 as per Dwg D412-694 page 3. Trim D3119-041 Cover Assembly and transfer Ø(#30) holes using hole finder tool from the door to the cover. Open holes to Ø5/32" (0.156).</p> <p>Pick:</p> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3119-041</td><td>Cover Assembly</td><td>B21853</td></tr></table>	Qty	Part Number	Description	Batch	1	D3119-041	Cover Assembly	B21853	ml	06/05/05	1																				
Qty	Part Number	Description	Batch																														
1	D3119-041	Cover Assembly	B21853																														
63	CA	<p>Open (#30) pilot hole to Ø"G" (0.261) in the door for ALS4-632-80 insert. Install insert as per Dwg D412-694 page 3.</p> <p>Pick:</p> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>10</td><td>ALS4-632-80</td><td>Thinwall Insert</td><td>M17841</td></tr></table>	Qty	Part Number	Description	Batch	10	ALS4-632-80	Thinwall Insert	M17841	ml	06/05/05	1																				
Qty	Part Number	Description	Batch																														
10	ALS4-632-80	Thinwall Insert	M17841																														
64	CA	<p>Install Doublers and D3159-041 bracket. Cut slot openings from the door to D3116-5-0680 Seal as per Dwg D412-694 page 3 (section JJ-JJ)</p> <p>Pick:</p> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3116-5-0680</td><td>Seal</td><td>B23699</td></tr><tr><td>1</td><td>D3144-1</td><td>Doubler</td><td>B18816</td></tr><tr><td>1</td><td>D3144-105</td><td>Doubler</td><td>B23143</td></tr><tr><td>1</td><td>D3144-107</td><td>Doubler</td><td>B23144</td></tr><tr><td>3438</td><td>BSP45</td><td>Rivet</td><td>M11821</td></tr><tr><td>128</td><td>BSP46</td><td>Rivet</td><td>M14230</td></tr></table>	Qty	Part Number	Description	Batch	1	D3116-5-0680	Seal	B23699	1	D3144-1	Doubler	B18816	1	D3144-105	Doubler	B23143	1	D3144-107	Doubler	B23144	3438	BSP45	Rivet	M11821	128	BSP46	Rivet	M14230	ml	06/05/04	1
Qty	Part Number	Description	Batch																														
1	D3116-5-0680	Seal	B23699																														
1	D3144-1	Doubler	B18816																														
1	D3144-105	Doubler	B23143																														
1	D3144-107	Doubler	B23144																														
3438	BSP45	Rivet	M11821																														
128	BSP46	Rivet	M14230																														

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PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	24659
Description: Door Assembly	Part Number:	D412-694-01
		D412-694-03
Dwg: D412-694 Rev. B page 2,3,4,5,6	Qty:	1
Ref: D3140 Rev. C page 1, 2		Page 10 of 11

Step	Location	Procedure	By	Date	Qty																												
65	CA	Install D3150-1 Guide top/bottom as per Dwg D412-694 page 5 (view DD & CC). Note: Install D3128-1 shim as required. Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>D3149-1</td><td>Striker Plate</td><td>M10536-17</td></tr><tr><td>2</td><td>D3150-1</td><td>Guide</td><td>M10536-17</td></tr><tr><td>4</td><td>AN960JD10LL</td><td>Washer</td><td>M11763</td></tr><tr><td>4</td><td>MS21042L3</td><td>Nut (or -3)</td><td>M15539</td></tr><tr><td>4</td><td>MS24694-S56</td><td>Screw</td><td>M14198</td></tr></table>	Qty	Part Number	Description	Batch	2	D3149-1	Striker Plate	M10536-17	2	D3150-1	Guide	M10536-17	4	AN960JD10LL	Washer	M11763	4	MS21042L3	Nut (or -3)	M15539	4	MS24694-S56	Screw	M14198	ml	06/05/04	1				
Qty	Part Number	Description	Batch																														
2	D3149-1	Striker Plate	M10536-17																														
2	D3150-1	Guide	M10536-17																														
4	AN960JD10LL	Washer	M11763																														
4	MS21042L3	Nut (or -3)	M15539																														
4	MS24694-S56	Screw	M14198																														
66	QC5	Inspect work to Step 65		06/05/08	1																												
67	CA	Install Hinge Bracket and D3113-1 Spring as per Dwg D412-694 page 3 & 4 (view MM-MM). Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3113-1</td><td>Spring</td><td>B17437</td></tr><tr><td>1</td><td>D3114-1</td><td>Pivot</td><td>B18630</td></tr><tr><td>1</td><td>D3145-1</td><td>Bracket</td><td>B26502-1</td></tr><tr><td>1</td><td>D3146-1</td><td>Bracket</td><td>B26709</td></tr><tr><td>6</td><td>AN960JD10LL</td><td>Washer</td><td>M11763</td></tr><tr><td>6</td><td>MS27039-1-08</td><td>Screw</td><td>M13356</td></tr></table>	Qty	Part Number	Description	Batch	1	D3113-1	Spring	B17437	1	D3114-1	Pivot	B18630	1	D3145-1	Bracket	B26502-1	1	D3146-1	Bracket	B26709	6	AN960JD10LL	Washer	M11763	6	MS27039-1-08	Screw	M13356	ml	06/05/04	1
Qty	Part Number	Description	Batch																														
1	D3113-1	Spring	B17437																														
1	D3114-1	Pivot	B18630																														
1	D3145-1	Bracket	B26502-1																														
1	D3146-1	Bracket	B26709																														
6	AN960JD10LL	Washer	M11763																														
6	MS27039-1-08	Screw	M13356																														
68	CA	Install top/bottom Covers. Attach D3116-11-0180 Seal as per Dwg D412-694 page 3 Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3116-11-0180</td><td>Seal</td><td>B24675</td></tr><tr><td>1</td><td>D3120-1</td><td>Cover</td><td>M10536-17</td></tr><tr><td>1</td><td>D3120-3</td><td>Cover</td><td>B17423</td></tr><tr><td>10</td><td>AN960JD10LL</td><td>Washer</td><td>M11763</td></tr><tr><td>10</td><td>MS27039-1-06</td><td>Screw</td><td>M11754</td></tr><tr><td>A/R</td><td>732 RTV Clear</td><td>Sealant</td><td>M16368</td></tr></table> Expiry Date: 17 Feb. 2007	Qty	Part Number	Description	Batch	1	D3116-11-0180	Seal	B24675	1	D3120-1	Cover	M10536-17	1	D3120-3	Cover	B17423	10	AN960JD10LL	Washer	M11763	10	MS27039-1-06	Screw	M11754	A/R	732 RTV Clear	Sealant	M16368	ml	06/05/03	1
Qty	Part Number	Description	Batch																														
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69	CA	Install D3119-041 Cover and Assemble Handle as per Dwg D412-694 page 3 & 5 (section BB-BB). Align properly. Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3110-1</td><td>Escutcheon</td><td>B24673</td></tr><tr><td>2</td><td>MS24694-C4</td><td>Screw</td><td>7 M19098 M15924</td></tr><tr><td>15</td><td>NAS388-6-8P</td><td>Screw</td><td>8 M11819</td></tr><tr><td>1</td><td>NAS388-6-12P</td><td>Screw</td><td>M11542</td></tr><tr><td>16</td><td>NAS391B6P</td><td>Washer</td><td>M11761</td></tr></table>	Qty	Part Number	Description	Batch	1	D3110-1	Escutcheon	B24673	2	MS24694-C4	Screw	7 M19098 M15924	15	NAS388-6-8P	Screw	8 M11819	1	NAS388-6-12P	Screw	M11542	16	NAS391B6P	Washer	M11761	ml	06/05/08	1				
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70	QC5	Inspect parts for 100% completeness on the W/O		06/05/08	1																												

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

UPDATED

DART AEROSPACE LTD		Work Order: 24659
Description: Door Assembly		Part Number: D412-694-01
		D412-694-03
Dwg: D412-694 Rev. C page 2,3,4,5,6		Qty:
Ref: D3140 Rev. D page 1, 2		Page 11 of 11

Step	Location	Procedure	By	Date	Qty																																																																								
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Rev	Date	Change	Revised By	Approved
A	05.12.09	New issue	KJ/RF	

PRELIMINARY ISSUE

PART AEROSPACE LTD		Work Order:	24659
Description: Door Assembly		Part Number:	D412-694-01
			D412-694-03
Dwg: D412-694 Rev. B page 2,3,4,5,6		Qty:	1
Ref: D3140 Rev. C page 1, 2		Page 11 of 11	

REFERENCE ONLY

Ref: D3146 Rev: 0 Page: 2				By	Date	Qty		
Step	Location	Procedure						
71	KP	Pick: Packing Kit						
		Qty	Part Number	Description	Batch			
		1	D2126-0730	Seal	B25702			
		2	D3090-1	Shim	B16578			
		2	D3090-3	Shim	B18040			
		1	D3108-1	Decal	B18625			
		1	D3108-2	Decal	B17030			
		2	D3108-3	Decal	B18627			
		2	D3108-5	Decal	B17205			
		1	D3108-7	Decal	B18163			
		1	D3116-1-0500	Seal	B17295			
		1	D3116-3-0500	Seal	B17296			
		2	D3118-3	Sign Assembly	B24281			
		2	D3118-5	Sign Assembly	B23863 B	24698		
		2	D3128-1	Shim	B18643			
		1	D3300-1	Window	B26396-2			
72	QC4	Inspect Kit for 100% completeness on the W/O						
73	AC	75% for D412-694-01 _____ Cost / part: _____ 25% for D412-694-03 _____						
74	DC	Close W/O Inspect Level 21						

24698

6/5/8 ①

C.L. 0440-508 ①

Rev	Date	Change	Revised By	Approved
A	05.06.28	New issue	KJ/RF	<i>[Signature]</i>

PRELIMINARY ISSUE

DART AEROSPACE LTD	Work Order:	24659
Description: Door Assembly	Part Number:	D412-694-01
		D412-694-03
Dwg: D412-694 Rev. B page 2,3,4,5,6	Qty:	1
Ref: D3140 Rev. C page 1, 2		Page 11 of 11

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Rev	Date	Change	Revised By	Approved
A	05.06.28	New issue	KJ/RF	<i>[Signature]</i>

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Feuille de Procédé

Client	: DART	Dart Aerospace Ltd.	Nom Dessin	: DOOR	
Numéro Job	: 32413		Numéro Article	: DKC135-0008/-0009	
Numéro Soumission	: 1725		Numéro Dessin	: D3140	
Numéro B.A.	:		Projet Numéro	: DKC135	
Cette fois	: 2006-01-16	No. B.V. :	Révision dessin	: C	
Prsht Rev.	: NC		Matériel	: Tissu Fibercote E-761/7788	
Prem. fois	: - -	Type :	Date Dûe	: 2006-01-31	Qté: 1 Udm: UNITE
Job précédente	: 31583				

Écrit par : _____
Vérifié & Approuvé par : _____
Commentaires : N° de pièce Dart Aerospace: D3140-05/-07
N° de pièce Delastek Aeronautique: DKA359-0008/-0009
N° de pièce Delastek Composites: DKC135-0008/-0009
Process Sheet Rév.: 08

B24659

Produit additionnel

Numéro Job:



Séq.: Machine ou Opération: Description :

1.0 OUTILLAGE OUTILLAGE NÉCESSAIRE À LA FABRICATION



Commentaire Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
OUTILLAGES NÉCESSAIRES À LA FABRICATION DE LA PIÈCE

Moule N° B30-23000-01T
Patron de découpe N° B30-23000-57T
Patron de découpe N° B30-23000-61T
Patron de découpe N° B30-23000-63T
Patron de découpe N° B30-23000-71T
Patron de découpe N° B30-23000-73T
Patron de découpe N° B30-23000-75T
Patron de découpe N° B30-23000-77T
Patron de découpe N° B30-23000-79T
Gabarit de taillage N° B30-23000-05T (2 pièce) et N° B30-2300-03T
Forme de silicone N° B30-23000-07T

2.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs
PRÉPARATION DU MOULE

Préparation du moule selon la section 5.0 de l'instruction de travail TEC-77

Quantité: 1 Date: 30-01-06 Sceau: _____



Client: DART Dart Aerospace Ltd.

Nom Dessin: DOOR

Numéro Job: 32413

Numéro Article: DKC135-0008/-0009

Numéro Job:



Séq.: Machine ou Opération: Description:

3.0 AMB0211 PREPERG FIBERCOTE E761/7781 roul. 50"

Commentair Qty.: 12.3 VERGE(s)/Unit Total: 12.3 VERGE(s)
PREPERG FIBERCOTE E761/7781 roul. 50"

N° de Lot:

1-5262-1

4.0 PRÉPARATION 2 PRÉPARATION MATÉRIEL PLASTIC COMMERCIAL

Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run: 1.5000Hrs
DÉCOUPAGE MATÉRIEL

Découpe du tissu pré-imprégné e-761 paquets de 10.5 pi². (7 paquets = 24.5 Verges)

Quantité: 1

Date: 1-02-06

Sceau:



5.0 DRAPAGE 1 DRAPAGE DART

Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run: 3.0000Hrs
DRAPAGE DES PIÉCES

Faire le drapage de 3 plis de tissu pré-imprégné e-761 (4 Paquets) selon la section 8.1.1 de l'instruction de travail N° TEC-77.

Quantité: 1

Date: 2-02-06

Sceau:



6.0 AC0409 Tissu à délaminer Release ply B

Commentair Qty.: 4.37 VERGE(s)/Unit Total: 4.37 VERGE(s)
Tissu à délaminer Release ply B

7.0 AC0407 Wrightlon 5200 Bleu P3

Commentair Qty.: 7.18 VERGE(s)/Unit Total: 7.18 VERGE(s)
Wrightlon 5200 Bleu P3

8.0 AC0408 Feutre de drainage N° Airweave N 10

Commentair Qty.: 6.00 VERGE(s)/Unit Total: 6.00 VERGE(s)
Feutre de drainage N° Airweave N 10

9.0 AC0755 Sac à vide N° Stretchlon 700

Commentair Qty.: 7.770 METRE CAR(s)/Unit Total: 7.770 METRE CAR(s)
Sac à vide N° Stretchlon 700

10.0 AC0098 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.0000 RL(s)/Unit Total: 2.0000 RL(s)
Ruban à gommer jaune #: T/AT-200Y

Client: DART Dart Aerospace Ltd.

Nom Dessin: DOOR

Numéro Job: 32413

Numéro Article: DKC135-0008/-0009

Numéro Job:



Séq.: Machine ou Opération: Description :

11.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentair. Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs
EFFECTUER LA POCHE A VIDE

Faire le montage cuisson selon la section 8.2.1 de l'instruction de travail N° TEC-77.

Quantité: 1

Date: 2-02-06

Sceau:



12.0

CUISSON 1

CUISSON PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
CUISSON DES PIECES

Faire la cuisson selon la section 8.3.1 de l'instruction de travail N° TEC-77

Quantité: 1

Date: 2-02-06

Sceau:

# CUISSON
4770

13.0

DÉMOULAGE 1

DÉMOULAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs
DÉMOULAGE DES PIECES

Retirez le montage cuisson et faire les retouches de la pièce, afin d'enlever les surplus de résines et les résidus de tissu à délaminer.

Quantité: 1

Date: 3-02-06

Sceau:



14.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
INSPECTION GÉNÉRALE

Vérification de la première coquille pour s'assurer qu'il n'y aie pas de réparation à faire avant la prochaine étape.

Quantité: 1

Date: 3-02-06

Sceau:



15.0

ACP0004

Klegecell TR75 1"thick 4'x8' plain

Commentair Qty.: 2.0 UNITE(s)/Unit Total: 2.0 UNITE(s)
Klegecell TR75 1"thick 4'x8' plain

N° de Lot: 1-5341-1

Client: DART Dart Aerospace Ltd.

Nom Dessin: DOOR

Numéro Job: 32413

Numéro Article: DKC135-0008/-0009

Numéro Job:



Séq.:

Machine ou Opération:

Description :

16.0

DÉCOUPE

DÉCOUPAGE PRIMAIRE



Commentair Setup: 0.00Hrs/ Run: 360.0000Min Total Run : 6.0000Hrs
DÉCOUPAGE PRIMAIRE

Faire la découpe des pièces de mousse structurales (Klegecell) sur la scie à ruban selon la section 8.1.2
de l'instruction de travail N° TEC-77.

Quantité: 1

Date: 20-03-06

Sceau:



17.0

AAC0560

FILM ADHESIF PF-7035-C

Commentair Qty.: 55 UNITE(s)/Unit Total: 55 UNITE(s)
FILM ADHESIF PF-7035-C

N° de Lot: 1-5263-1

18.0

ACP0003

Core splice adhesive MA560.048

Commentair Qty.: 5 UNITE(s)/Unit Total: 5 UNITE(s)
Core splice adhesive MA560.048

N° de Lot: 1-5316-1

19.0

AAC0563

EPOCAST 87269-A/B

Commentair Qty.: 0.25 KIT(s)/Unit Total: 0.25 KIT(s)
EPOCAST 87269-A/B

N° de Lot: 2-5262-2

20.0

AAC0644

DOUBLER KIT D3140-5-7

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)
DOUBLER KIT D3140-5-7

N° de Lot: n/s

21.0

ASSEMBLAGE 3

ASSEMBLAGE GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs
ASSEMBLAGE GÉNÉRALE DES PIÈCES

Mise en place des doublers et des pièces de mousse structurales selon la section 8.1.3 de l'instruction de
travail N° TEC-77.

Quantité: 1

Date: 20-03-06

Sceau:



Client: DART Dart Aerospace Ltd.

Nom Dessin: DOOR

Numéro Job: 32413

Numéro Article: DKC135-0008/-0009

Numéro Job:



Séq.: Machine ou Opération: Description :

22.0 AC0409 Tissu à délaminer Release ply B

Commentair Qty.: 4.37 VERGE(s)/Unit Total: 4.37 VERGE(s)

Tissu à délaminer Release ply B

23.0 AC0407 Wrightion 5200 Bleu P3

Commentair Qty.: 7.18 VERGE(s)/Unit Total: 7.18 VERGE(s)

Wrightion 5200 Bleu P3

24.0 AC0408 Feutre de drainage N° Airweave N 10

Commentair Qty.: 6.00 VERGE(s)/Unit Total: 6.00 VERGE(s)

Feutre de drainage N° Airweave N 10

25.0 AC0755 Sac à vide N° Stretchlon 700

Commentair Qty.: 7.770 METRE CAR(s)/Unit Total: 7.770 METRE CAR(s)

Sac à vide N° Stretchlon 700

26.0 AC0098 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.0000 RL(s)/Unit Total: 2.0000 RL(s)

Ruban à gommer jaune #: T/AT-200Y

27.0 POCHE À VIDE 1 FAIRE LA POCHE À VIDE

Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run: 1.5000Hrs
EFFECTUER LA POCHE A VIDE

Faire le montage cuisson selon la section 8.2.2 de l'instruction de travail N° TEC-77

Quantité: 1

Date: 24-03-06

Sceau:



28.0 CUISSON 1 CUISSON PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs
CUISSON DES PIÈCES

Faire la cuisson des pièces selon la section 8.3.2 de l'instruction de travail N° TEC-77

Quantité: 1

Date: 24-03-06

Sceau:



#CUISSON 4880

29.0 DÉMOULAGE 1 DÉMOULAGE PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run: 0.5000Hrs
DÉMOULAGE DES PIÈCES

Retirez le montage cuisson de sur la pièce, et enlever les résidus de ruban adhésif en teflon et les barres d'aluminium, Garder seulement la barre qui sépare les deux pièces.

Quantité: 1

Date: 25-03-06

Sceau:



Client: DART Dart Aerospace Ltd.

Nom Dessin: D00R

Numéro Job: 32413

Numéro Article: DKC135-0008/-0009

Numéro Job:



Séq.: Machine ou Opération: Description :

30.0

DÉCOUPE CORE

DÉCOUPE DU CORE DART



Commentair Setup: 0.00Hrs/ Run: 210.0000Min Total Run : 3.5000Hrs

USINAGE DES MOUSSE

Usinage des mousses structurales selon la section 8.1.4 de l'instruction de travail N° TEC-77

Quantité: 1

Date: 27-03-06

Sceau:



31.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

INSPECTION GÉNÉRALE

Faire la vérification de l'usinage intérieur pour s'assurer que tout soit conforme au dessin avant la prochaine étape.

Quantité: 1

Date: 6-04-06

Sceau:



32.0

AMB0211

PREPERG FIBERCOTE E761/7781 roul. 50"

Commentair Qty.: 12.3 VERGE(s)/Unit Total : 12.3 VERGE(s)

PREPERG FIBERCOTE E761/7781 roul. 50"

N° de Lot: 1-5262-1

33.0

DRAPAGE 1

DRAPAGE DART



Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs

DRAPAGE DES PIÈCES

Drapage de la coquille intérieur selon la section 8.1.5 de l'instruction de travail N° TEC-77

Quantité: 1

Date: 8-04-06

Sceau:

INSTALLATION DES DOUBLES
OK 3-04-06 D3140-103104
105
106

7-04-06

34.0

AC0409

Tissu à délaminer Release ply B

Commentair Qty.: 4.37 VERGE(s)/Unit Total : 4.37 VERGE(s)

Tissu à délaminer Release ply B

35.0

AC0407

Wrightlon 5200 Bleu P3

Commentair Qty.: 7.18 VERGE(s)/Unit Total : 7.18 VERGE(s)

Wrightlon 5200 Bleu P3

Feuille de Procède

Client: DART Dart Aerospace Ltd.

Nom Dessin: DOOR

Numéro Job: 32413

Numéro Article: DKC135-0008/-0009

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
36.0	AC0408	Feutre de drainage N° Airweave N 10
Commentair Qty.: 6.00 VERGE(s)/Unit Total: 6.00 VERGE(s) Feutre de drainage N° Airweave N 10		
37.0	AC0755	Sac à vide N° Strechlon 700
Commentair Qty.: 7.770 METRE CAR(s)/Unit Total: 7.770 METRE CAR(s) Sac à vide N° Strechlon 700		
38.0	AC0098	Ruban à gommer jaune #: T/AT-200Y
Commentair Qty.: 2.0000 RL(s)/Unit Total: 2.0000 RL(s) Ruban à gommer jaune #: T/AT-200Y		
39.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE
Commentair Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs EFFECTUER LA POCHE A VIDE Faire le montage cuisson selon la section 8.2.3 de l'instruction de travail N° TEC-77. Quantité: <u>1</u> Date: <u>8-04-06</u> Sceau:		
40.0	CUISSON 1	CUISSON PIÈCE DART
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs CUISSON DES PIECES Faire la cuisson de la pièce selon la section 8.3.3 de l'instruction de travail N° TEC-77. Quantité: <u>1</u> Date: <u>8-04-06</u> Sceau:		
41.0	DÉMOULAGE 1	DÉMOULAGE PIÈCE DART
Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs DÉMOULAGE DES PIECES Retirez le montage cuisson, et faire de retouches sur la pièce afin d'enlever les surplus de résine et les résidus de tissu à délaminer. Retirer la pièce du moule. Quantité: <u>1</u> Date: <u>9-04-06</u> Sceau:		

Client: DART Dart Aerospace Ltd.

Nom Dessin: DOOR

Numéro Job: 32413

Numéro Article: DKC135-0008/-0009

Numéro Job:



Séq.:

Machine ou Opération:

Description :

42.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

TRIMAGE DE FINITION

Faire le trimage de finition de la pièce selon la section 8.5 de l'instruction de travail N° TEC-77.

Quantité: 1

Date: 9-04-06

Sceau:



43.0

AAC0671

Dupont Primer N° 1104S

Commentaire Qty.: 0.5000 GALLON(s)/Unit Total : 0.5000 GALLON(s)

Dupont Primer N° 1104S

N° de Lot: 1-5214-1

44.0

AAC0670

Dupont Activator N° 7975S

Commentaire Qty.: 1.0000 PINTE(s)/Unit Total : 1.0000 PINTE(s)

Dupont Activator N° 7975S

N° de Lot: 1-5214-3

45.0

AAC0672

Dupont Reducer N° 12375S

Commentaire Qty.: 0.1250 GALLON(s)/Unit Total : 0.1250 GALLON(s)

Dupont Reducer N° 12375S

N° de Lot: 1-5214-2

46.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

PRÉPARATION DU MATÉRIEL

Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

9-04-06



47.0

PEINT/ PRIMER2

PEINTURE / PRIMER DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

APPLICATION DE PRIMER

Appliquer une épaisse couche de primer partout sur les deux portes.

Quantité: 1

Date: 9-04-06

Sceau:



48.0

FINITION 3

FINITION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs

FINITION GÉNÉRALE

Faire un sablage léger (Grit 320-400) de toute les surfaces.

Quantité: 1

Date: 11-04-06

Sceau:



Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: DOOR

Numéro Job: 32413

Numéro Article: DKC135-0008/-0009

Numéro Job:



Séq.: Machine ou Opération: Description :

49.0 AAC0671 Dupont Primer N° 1104S

Commentair Qty.: 0.5000 GALLON(s)/Unit Total : 0.5000 GALLON(s)
Dupont Primer N° 1104S N° de Lot: 1-5214-1

50.0 AAC0670 Dupont Activator N° 7975S

Commentair Qty.: 1.0000 PINTE(s)/Unit Total : 1.0000 PINTE(s)
Dupont Activator N° 7975S N° de Lot: 1-5214-3

51.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.1250 GALLON(s)/Unit Total : 0.1250 GALLON(s)
Dupont Reducer N° 12375S N° de Lot: 1-5214-2

52.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs
PRÉPARATION DU MATÉRIELBien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant. 12-04-06

53.0 PEINT/PRIMER2 PEINTURE / PRIMER DART

Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
APPLICATION DE PRIMER

Application d'une couche de primer de finition partout sur les deux portes.

Quantité: 1 Date: 12-04-06 Sceau: 4

54.0 IDENTIFICATION4 IDENTIFICATION PIÈCES DART

Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
IDENTIFICATION DES PIÈCES

Identifier le numéro de la pièce, le numéro de job ainsi que la date de fabrication sur l'aluminium peinturé dans le dégagement des mécanisme de porte.

Grosse porte : D3140-05

Petite Porte: D3140-07

Quantité: 1 Date: 13-04-06 Sceau: 13

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: DOOR

Numéro Job: 32413

Numéro Article: DKC135-0008/-0009

Numéro Job:



Séq.:

Machine ou Opération:

Description :

55.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

INSPECTION GÉNÉRALE

Inspection finale par le département de la qualité selon le dessin D3140.

Date: 20/4/06 Sceau:



Initiales: NJ

56.0

EMBALLAGE 3

EMBALLAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

EMBALLAGE ET ENTREPOSAGE

Faire l'emballage selon la section 8.7 de l'instruction de travail N° TEC-77

Quantité: 1 Date: 20/4/06 Sceau:



ACTIVITY SUMMARY REPORT



DART AEROSPACE LTD
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

Attendees:


Report Type:

Subject:

Venue:

Date:

Item	Tues.	ITEM	Qty	TIME	Action / Date
	- Material 2024 .050 for template to mark 90° corners		8" x 8"	1.0	06/04/25
Tooling	* cut 8" Lg Legs 1 1/4" wide use notcher in 6-8		M1725		
Tooling	- cut MUHMW (Black plastic) 1" Thick		6" x 24"	1.5	
	* 4" x 4" Blocks cut to size, radius 1/16 - 1/8 on two sides and corner, smooth out with disc sander add 280 - 320 grit paper.				
	* Ensure surfaces are smooth and free of defects				
	<u>Wednesday</u>			9.0	06/04/26
	- Using Template, attach two sided tape to back surface of aluminum Template.				
	- cut out corners using template as guide				
	- Xacto knife, utility knife; score surface until thru to foam core				
	use R/A grinder with asstd disc's to remove edge and filler material				
	- use long nose pliers to remove the top surface of glass laminate				
	- R/A grinder, using assorted discs remove front portion of glass and filler material				
	- fabricate a chisel edge spatula from 2024 .050 1" x 8", grind edge knife				

ACTIVITY SUMMARY REPORT				
 <p>DART AEROSPACE LTD 1270 Aberdeen Street Hawkesbury, ON K6A 1K7</p>	Attendees:		Report Type:	
			Subject:	
			Venue:	
			Date:	
			Sheet _____ of _____	
Item	Action / Description	Responsible	Due Date	Action / Date
	<p>use chisel edge spatula remove foam core.</p> <p>- with core removed, taper the edges from the outside to the corner with R/A grinder and asstd Discs</p> <p>** Careful not to remove glass from bottom surface, foam core and adhesive only</p> <p><u>Thursday</u></p> <p>- Hand Sand areas around repair, remove primer and feather out edges, should be approx. $\frac{1}{2}$ - $\frac{3}{4}$ in back from edge to promote adhesion</p> <p>- Mfg. doubler for corners to allow for fibreglass buildup after the 934 cures and is sanded smooth - doubler is to be removed</p> <p>QC Required</p> <p><i>19 Dec 27</i></p> <p>- Used EA 934 Hysol A/B MIXED with chopped strands Fibreglass as a filler</p> <p>- applied to corners use plastic release cloth, place doubler and MuMMW jig into corner and force. The filler should</p>	<p>180 - 320 grit</p> <p>020 2024 M11622</p> <p>M19420 M14828</p>	<p>5.0</p> <p>3.5</p>	<p>06/04/27</p>

ACTIVITY SUMMARY REPORT



DART AEROSPACE LTD
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

Attendees:

Report Type:

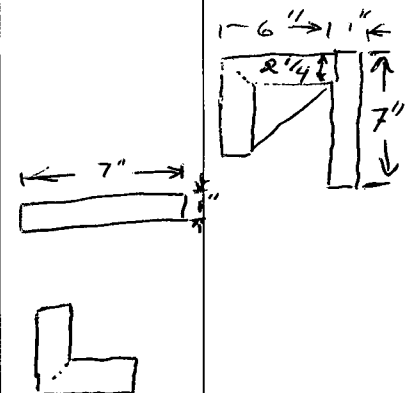
Subject:

Venue:

Date:

Sheet of

Item	Action / Description	Responsible	Due Date	Action / Date
	<p>Squeeze out along edges from excess.</p> <p>Remove excess 934 and chopped STRANDS with Tongue depressor.</p> <p>Remainder press down into space with finger, it should be at the height of the edge.</p> <p>Let cure</p> <p><u>Friday</u></p> <p>- Sand 934 and chopped f/g SMOOTH</p> <p>- clean surface, prepare for Fibreglass layup.</p> <p>- Mix 9309 NA A/B cut pieces of fibreglass 9oz approx 8"x10" QTY @ 8</p> <p>- place f/g on plastic, apply approx 65g of mixed resin onto a 8"x10" Fibreglass, fold over other side of plastic and squeeze resin throughout material, ensure resin is even throughout and not excess or STARVED areas</p> <p>- Draw onto plastic sections that require to cut</p> <p>- place 1"x7" section into corner and along edges evenly</p> <p>- the L shape, cut from the inside corner out leaving approx 1/2"</p>	<p>M1880</p> <p>M14828</p>	<p>9.5</p>	<p>06/04/28</p>



ACTIVITY SUMMARY REPORT



DART AEROSPACE LTD
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

Attendees:

Report Type:
Subject:
Venue:
Date:
Sheet <u> </u> of <u> </u>

Item	Action / Description	Responsible	Due Date	Action / Date
	<ul style="list-style-type: none"> - place L shape evenly into and on the corner, using acid brush and resin, press into corner remove air bubbles as you do it - place triangle section into corner, again using brush with resin to push it slightly into corner - prior to applying Peel ply, inspect all layers of fibreglass for air pockets, using acid brush and resin ensure all are removed. - apply Peel ply carefully, pay close attention to corner and not to lift up any of the laminate - place block of MuHw into corner firmly and clamp in place - Let cure <p>Monday May</p> <ul style="list-style-type: none"> - remove blocks and Peel ply sand smooth using right angle grinder with assorted grits, Hand sand using 180 and 320 all edges should be feathered / tapered back <p><u>QC Required</u></p>	MI4245	<p>5.0</p> <p>06/05/01</p>	<p>06/05/01</p> <p>QC 05 02</p>

Friday 28 April

To : Roberto

from : Monique

Subject : S.O.S!!! small door (-03)

ACCEPTABLE DEVIATION
THIS DOOR ONLY.
PLEASE ATTACH TO W/O.

06.05.05

ATTN: SERGE @ 613-632-4443
pg #1 of 2

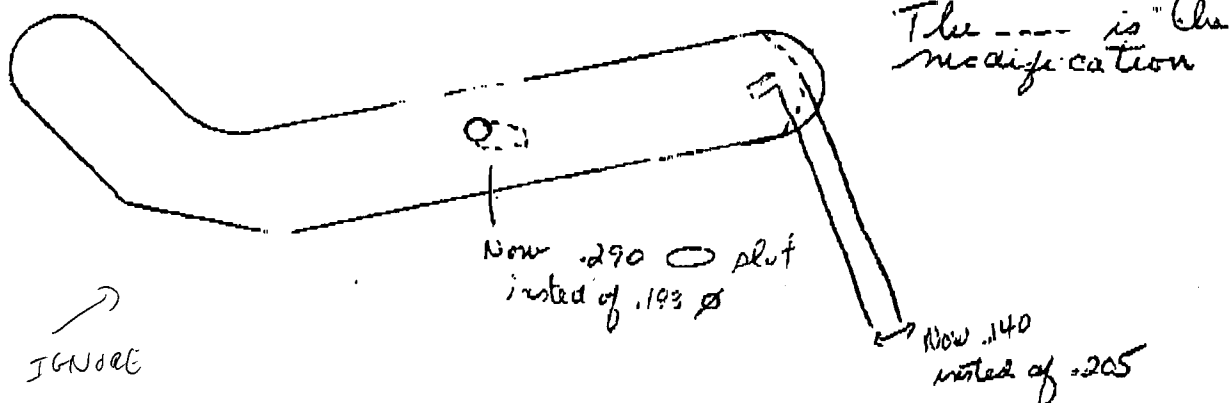
Hello. For many reason I have made
Holes of D3125-1 to high. (please don't ask ☺)
it is the lever at the top.

I tried to fix it with

- 1) grind the top of D3125-1
- 2) make the hole (hold the pin) larger
- 3) Have to make a new hole

D3134-3

Is it possible to plug this hole and re-do it lower?



please answer me!



Monique

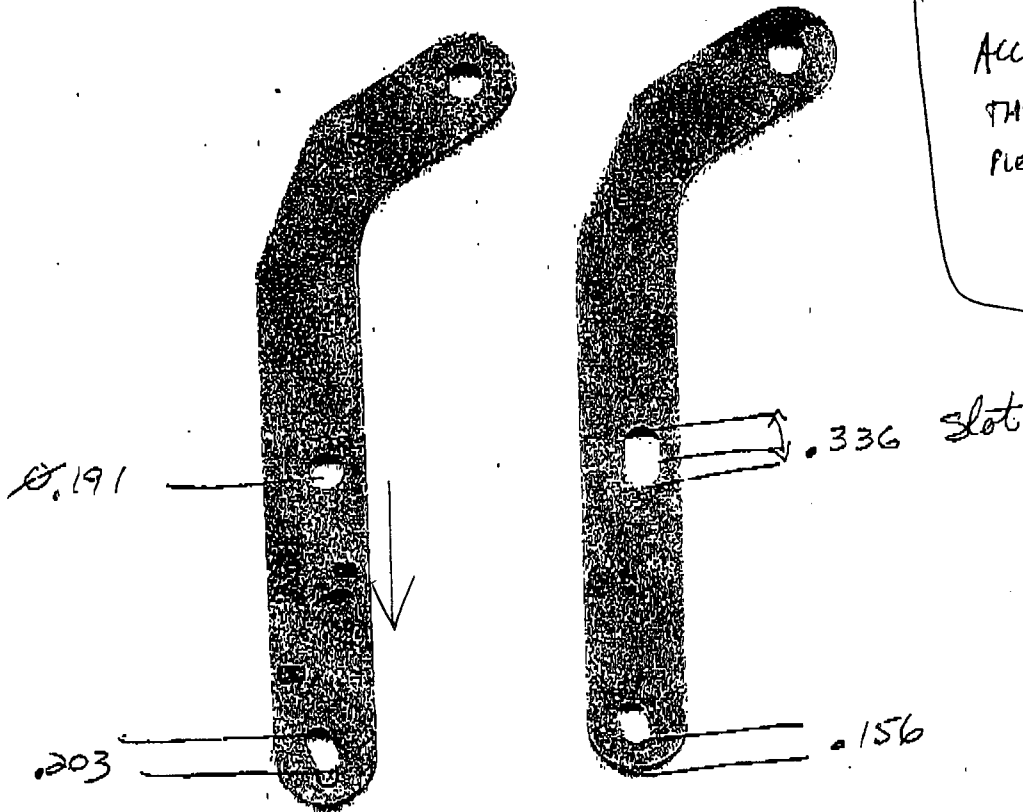
w/o 24659

ACCEPTABLE DEVIATION

THIS DOOR ONLY

PLEASE ATTACH TO W/O

ff 05.05

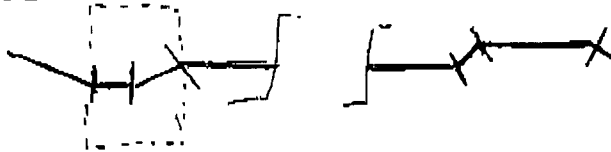
WASNow

D3125-1 LEVER (TOP OF DOOR)

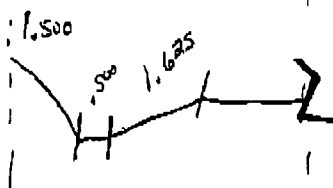
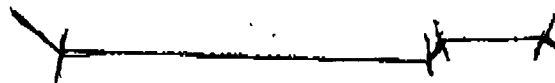
About D3134-3

New length : 27.500

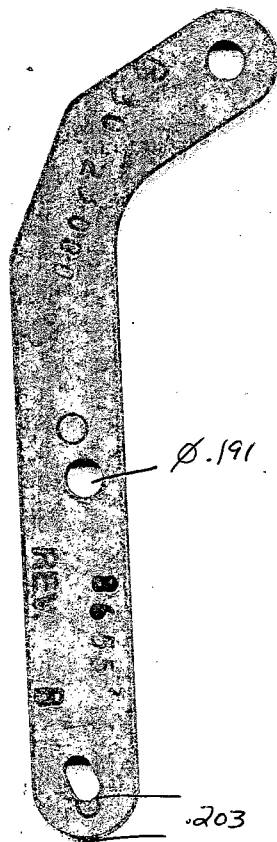
New profile :



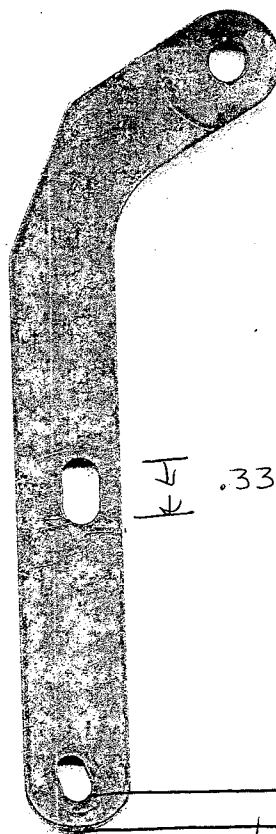
instead of



w/o 24659



WAS



NOW

Friday 28 April

412-694-011

DE 1261

W/O 25203

ACCEPTABLE DEVIATION
THIS DOOR ONLY.
PLEASE ATTACH TO W/O.

To: Roberto

06.05.05

from: Monique

ATTN: SERGE @ 613-632-4443
pg #1 of 2

Subject: S.O.S!!! small door (-03)

Hello. For many reason I have made

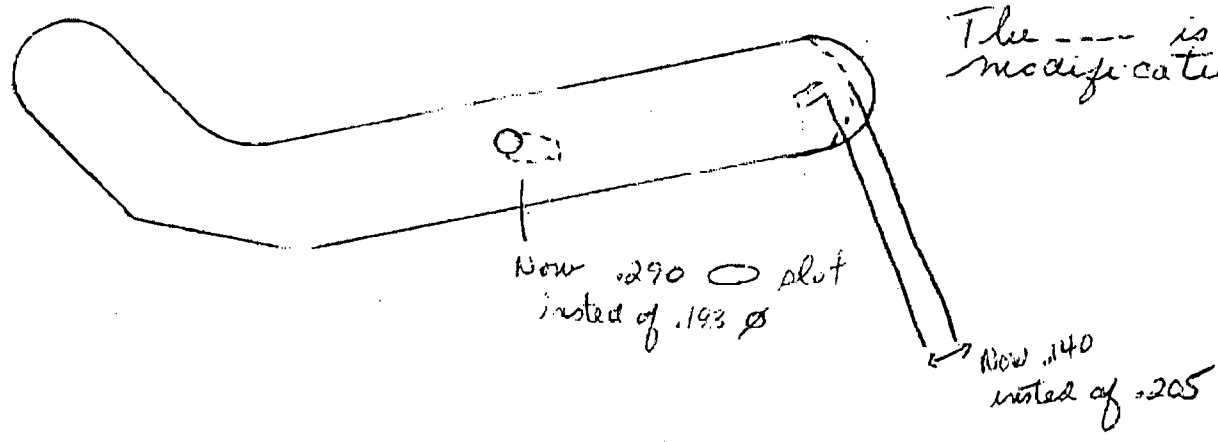
Holes of D3125-1 to high. (please don't ask ☺)
it is the lever at the top.

I tried to fix it with

attach to spacedoor
order shipped
on May 8th

D3125-1
(d the pin) larger
new hole
D3134-3

Is it possible to plug this hole and re-do it lower?



please answer me!



Monique

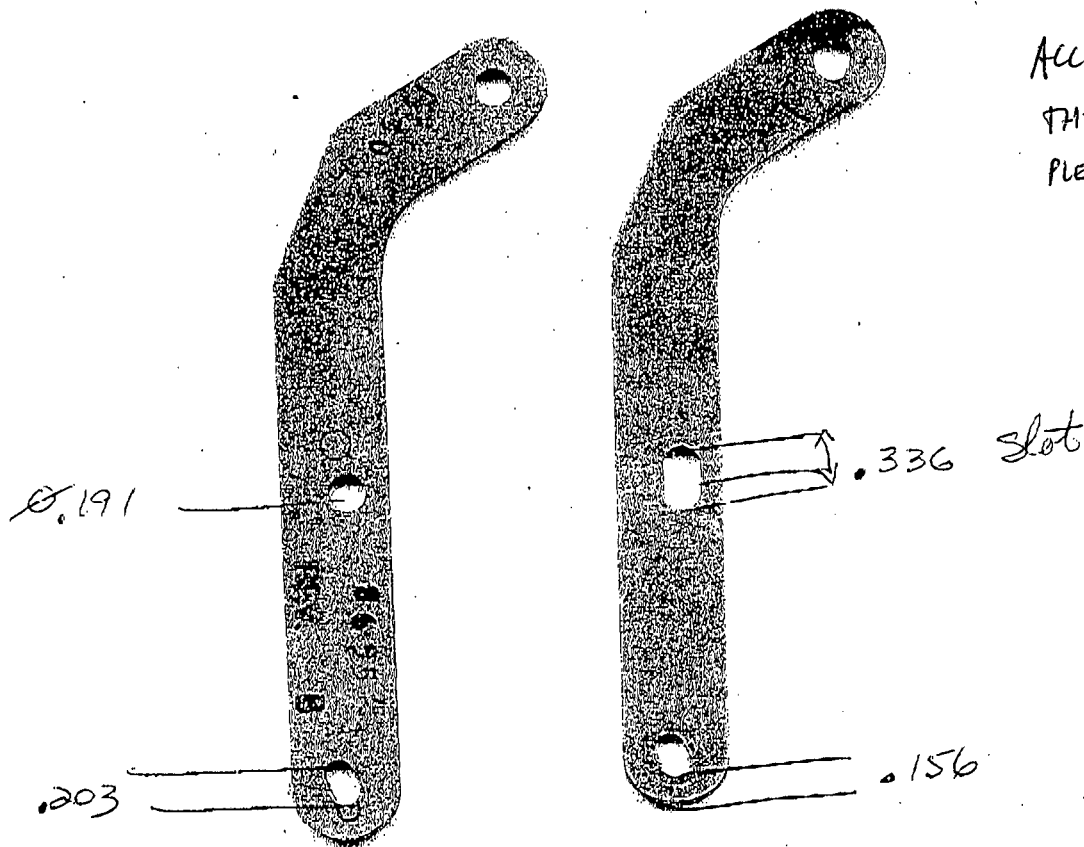
w/o 24659

ACCEPTABLE DEVIATION

THIS DOOR ONLY

PLEASE ATTACH TO W/O

06.05.05



WAS

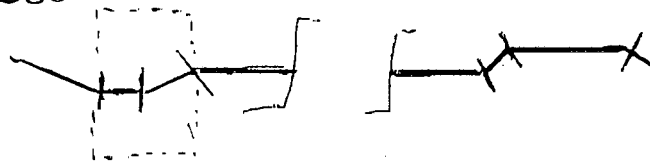
Now

D3125-1 LEVER (TOP OF DOOR)

About D3134-3

New length : 27.500

New profile :



instead of

